



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE105-13141W5
Job Sheet 171312



Part No: RBE105-13141W5

Job Qty: 1 ea

Part Name: Staking Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/31/18

Job Tracking No:

Due Date: 3/21/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG RBE105-13141W5 Rev 1 IPP Rev A 18.01.30 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		3/21/18	0.00	0.00	Purchasing		AC 18/03/28
110	Packaging	1 pcs		3/21/18	0.00	0.00	Packaging2		AC 18/03/28
120	QC	1 pcs		3/21/18	0.00	0.00	QC6		38
130	Packaging	1 pcs		3/21/18	0.00	0.00	Packaging3		9-89
140	QC21-FG	1 Ea		3/21/18	0.00	0.00	QC21		GA 134

Part Op 100 - Issue P/O: 038936 MANUFACTURE RBE105-13141W5 AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

DAS
21
9-89

APR 03 2018 FEB 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE105-13141W5P	Staking Tool	1 (1 ea)	100-Purchasing	5055768

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBE105-13141W5P	1	0	0

Part Specifications

Specifications could not be found.

Plex 1/31/18 7:16 AM dart.lavoie.chantal

PART NO: RBE105 – 13141W5

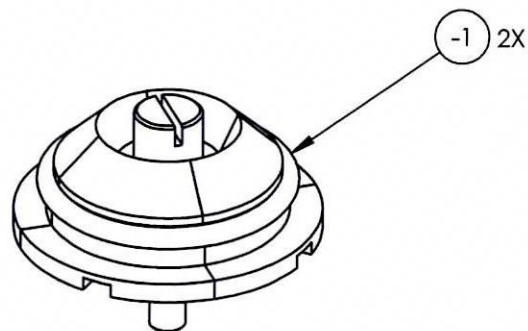
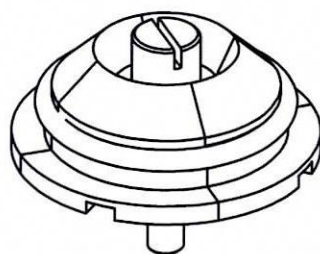
Revision:

Mfg Date: 03/28/18

Job No: 171312

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	10/7/2016	RJC	JAG



NOTE:

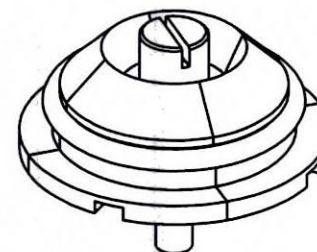
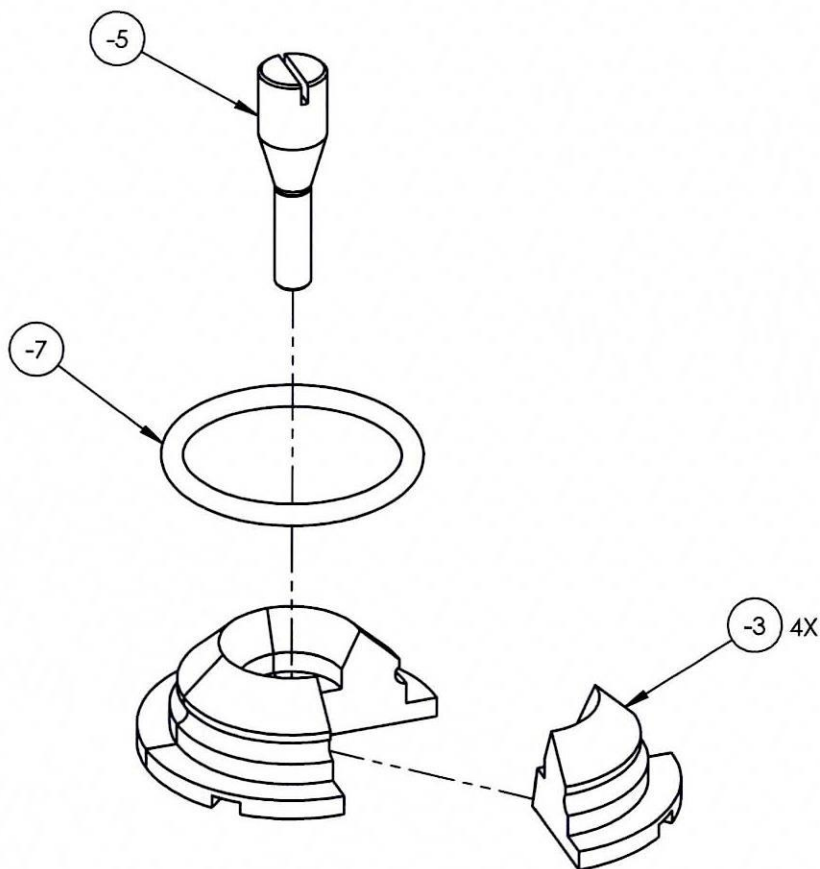
1. REF. EUROCOPTER T/N: 105-13141W5.
2. USED ON MODELS: EC135, EC145, H135, EC635, EC645.

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-13141W5	REV 1
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	SEE NOTE
APPROVED: GILBERT	
SCALE 1:1	DATE 7/22/2016 SHEET 1 OF 4

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	2	STAKING INSERT ASSEMBLY			2
	4		-3		STAKING INSERT	4140/4142		3
	1		-5		SCREW	4140/4142		4
		B/O	-7	1	O-RING	BUNA-N	Ø3mm X 30mm I.D. (MCMASTER-CARR #1174N608)	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

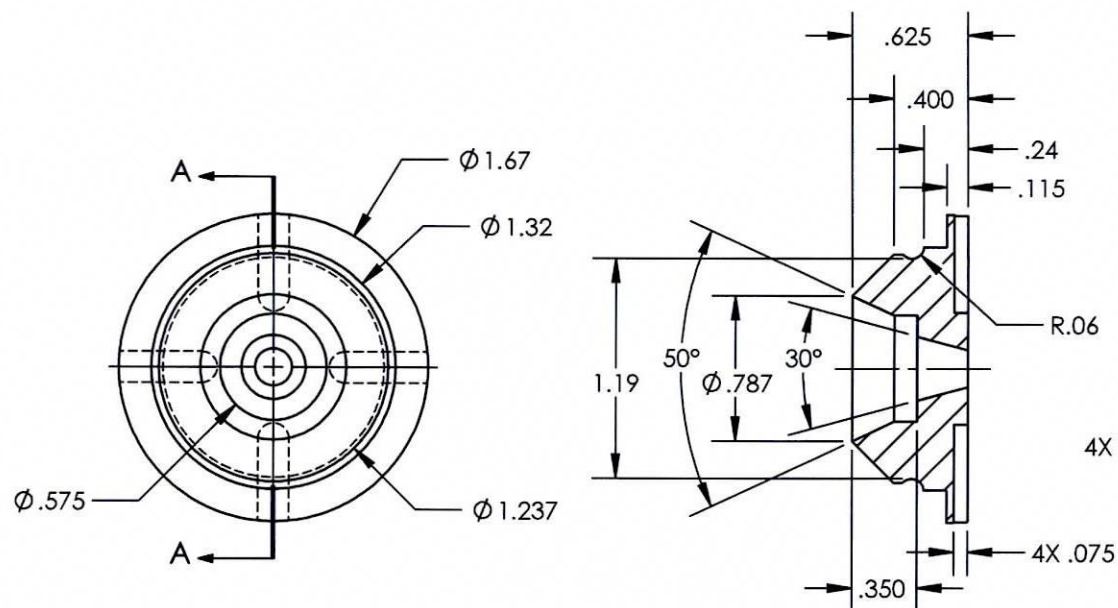


(1)
STAKING INSERT ASSEMBLY

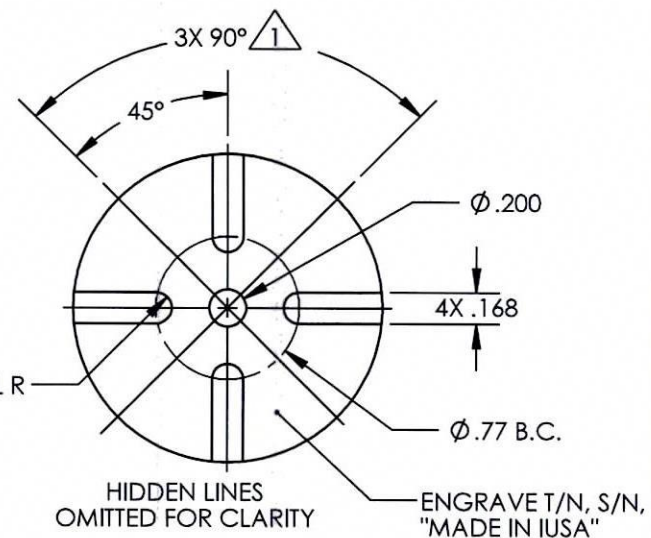
DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-13141W5-1	REV 1
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:1	DATE 7/22/2016
SHEET 2 OF 4	

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED



SECTION A-A



NOTE:

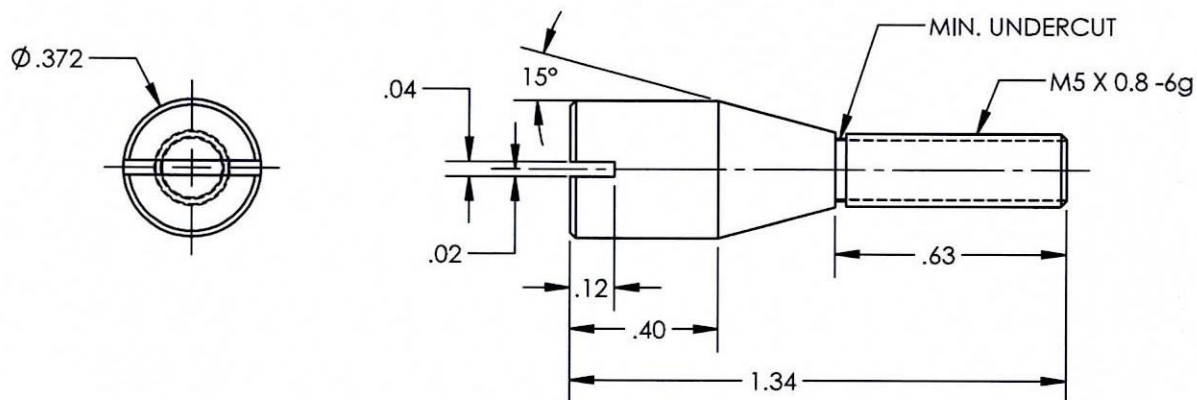
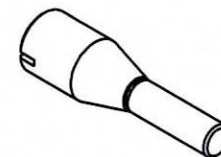
1 EDM TO SPLIT INTO 4 EQUAL PIECES.

③
STAKING INSERT

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-13141W5-3	REV 1
MAT'L 4140/4142 TREAT RC 55-60 FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/16 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
USED ON MODEL EC145	
SCALE 1:1	DATE 7/22/2016 SHEET 3 OF 4

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



(-5)
SCREW

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-13141W5-5	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 50-55	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: CLOUGH	X ± .1 SURFACES = 125/
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 7/21/2016	USED ON MODEL
SHEET 4 OF 4	EC145



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038936

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038936
PO Date: 2/2/18
Due Date: 3/23/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
FEB 02 2018
comf

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	RBE105-13141W5P			Staking Tool As Per Dwg RBE105-13141W5 Rev. 1	Firmed	3/23/18	1 Ea / 1x	0 Ea	1 Ea	\$970.00/Ea	\$970.00
Line Item Note job# 171312										Grand Total:	\$970.00

Order Notes											
Procurement Quality Clauses A005 RIGHT OF ENTRY A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE) A012 CHEMICAL AND PHYSICAL TEST REPORTS A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A026 CERTIFICATION OF MATERIAL CONFORMANCE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENT A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM A049 SUPPLIER AWARENESS Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.											

Plex 2/2/18 1:06 PM dart.baker.diane



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	P.O. Number
1 set	RBE105-13141W5 REV 1	STAKING TOOL	38936

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink that reads "Heather Nixon".

Heather Nixon

Vankleek Hill, March 27, 2018